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NOTES:

- 1 IDENTIFY IAW MPP-120
- A 2 MATERIAL: 3K 2X2 TWILL CARBON FIBER PREPREG, AXIOM AX-5112T
- 3 MATERIAL: #120 E-GLASS EPOXY PREPREG WITH 48% RC
4. MANUFACTURE IAW MPP-145
- 5 PRIME PARTS WITH TWO COATS IAW MIL-PRF-85582C, TYPE 1, CLASS N
6. INSPECT DIAMETERS ON ALL HOLES
- 7 PART GEOMETRY AND HOLE LOCATION DIMENSIONS CONTROLLED BY CAD MODEL.
FORMAT FILE NAME AS:
"652.26XX(PART NUMBER) XXX(Revision Level) XXXXXXXXXXXX (PART DESCRIPTION) XX-XX-XX(DATE)"
- B 8. INSPECT IAW DA169ATP-4.
- 9 LAYER THICKNESS TO TRANSITION OVER 1.00-1.50 IN
- 10 CURED AT 250°F WITH RAMP RATE OF 1-3 DEGREES PER MINUTE, HOLD AT 250°F FOR 60 MINUTES
- 11 ZERO DEGREE WARP DIRECTION LISTED ON CORRESPONDING PART DRAWINGS
- 12 DELETED
- 13 MATERIAL: AR 4315HP ADHESIVE, RESINLAB L.L.C
- C 14 INSTALL DOUBLER F/N 5-10 USING ADHESIVE F/N 11 CONCENTRIC TO FLANGE HOLES IN F/N 1 OR 2 AND .200" HOLES MATCH PUNCHED AND DRILLED PRIOR TO PRIMER DELTA 5.
- 15 MAX WEIGHT: 6.86 LBS.
- 16 MAX WEIGHT: 2.95 LBS.
- 17 APPLY PLY G1 ONLY WHERE SHOWN
- 18 APPLY PLY G2 ONLY WHERE SHOWN
- 19 APPLY MINIMUM 2.00 X 2.00 SQUARES AROUND HOLE LOCATIONS SHOWN.
2.00 WIDE STRIPS ALLOWED
TO STRETCH BETWEEN HOLES THAT ARE LESS THEN 3.00 APART.
- D 20 APPLY MINIMUM 3.00 X 3.00 SQUARES AROUND HOLE LOCATIONS SHOWN.

REVISIONS			
REV.	DESCRIPTION	DATE	APPROVED
	PREVIOUS PROTOTYPE REVISION PR19		
N/C	INITIAL DRAWING RELEASE	06-14-21	P. BRAVO
A	INCORPORATED ECN 06962	03-24-22	J.GARDINER

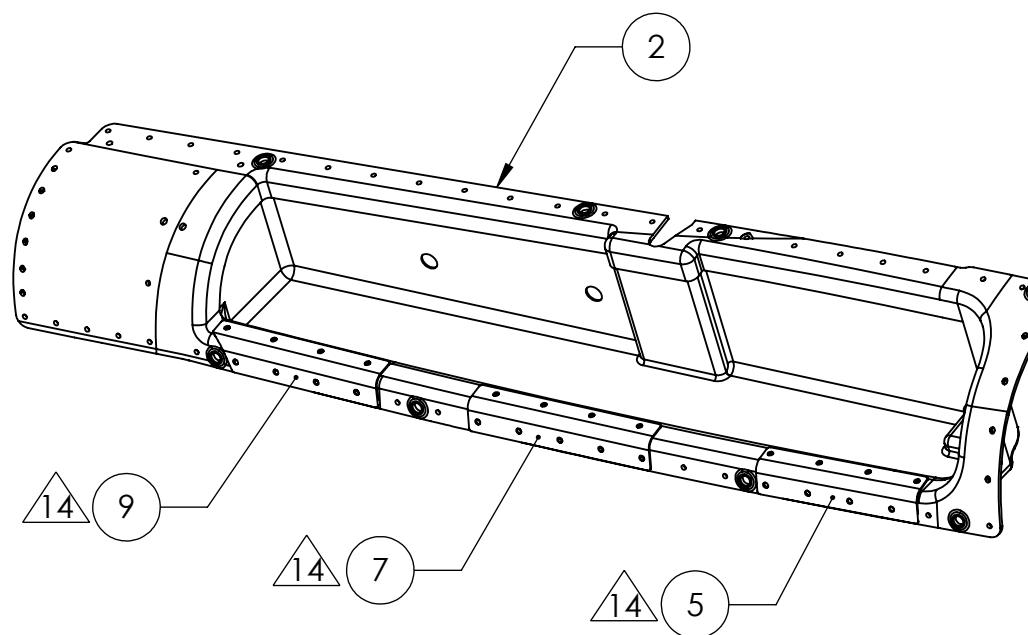
A/R	A/R	11	600.1005	ADHESIVE	13	
1		10	654.7025	RIGHT HAND 3RD DOUBLER (FWD)		
	1	9	654.7024	LEFT HAND 3RD DOUBLER (FWD)		
1		8	654.7023	RIGHT HAND 2ND DOUBLER (FWD)		
	1	7	654.7022	LEFT HAND 2ND DOUBLER (FWD)		
1		6	654.7021	RIGHT HAND 1ST DOUBLER (FWD)		
	1	5	654.7020	LEFT HAND 1ST DOUBLER (FWD)		
		4	652.2613	FWD COVER LH	2	5 7 16
		3	652.2612	FWD COVER RH	2	5 7 16
	1	2	652.2611	FWD POD LH	3	5 7
1		1	652.2610	FWD POD RH	2 3	5 7
X			652.2602	FWD POD ASSY RH		5
	X		652.2601	FWD POD ASSY LH		5
2602	2601	FIND #	PART #	DESCRIPTION	MAT'L	SPEC.

QTY		PARTS LIST		
NEXT ASSY (S)		ORIGINAL DATE (MO-DA-YR)	05-26-18	
652.2400		DRAWN BY	CHECKER	
		E.ANDERSSON	P.BRAVO	
		DRAWING APPROVAL		
		P.BRAVO	06-14-21	
		CONTRACT No.		
		UNLESS OTHERWISE SPECIFIED		
		DIMENSIONS ARE IN INCHES		
		TOLERANCES ARE:		
		2 PLACE DECIMALS $\pm .01$		
		3 PLACE DECIMALS $\pm .005$		
		ANGLES $\pm .5^\circ$		
SIZE	CAGE CODE	DWG. NO.		
B	07MZ6	652.2600	REV.	A
SCALE	NONE		SHEET	1 OF 11

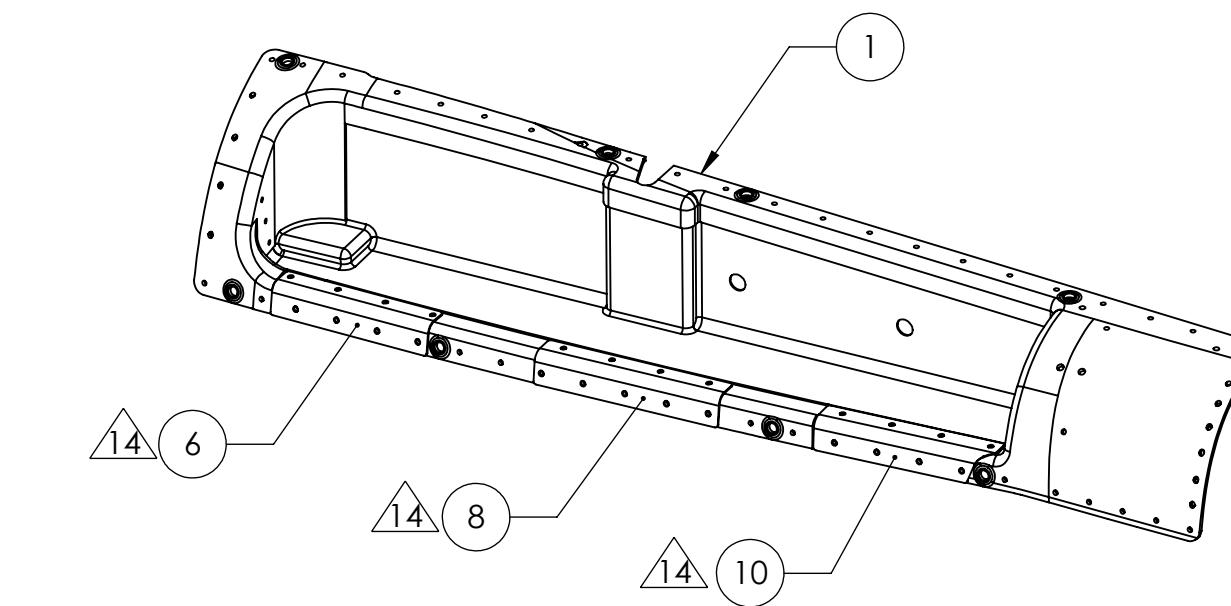
DART
AEROSPACE
3030 ENTERPRISE CT.,
SUITE A,
VISTA, CA. 92081
(760)-724-5300
APICAL INDUSTRIES, INC.
dba DART AEROSPACE

AW169 FWD POD AND COVER

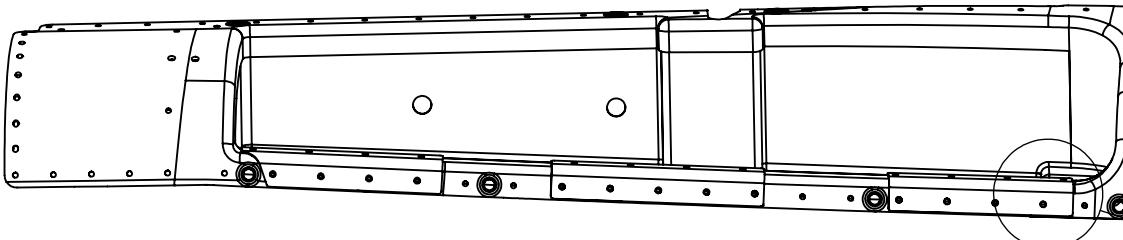
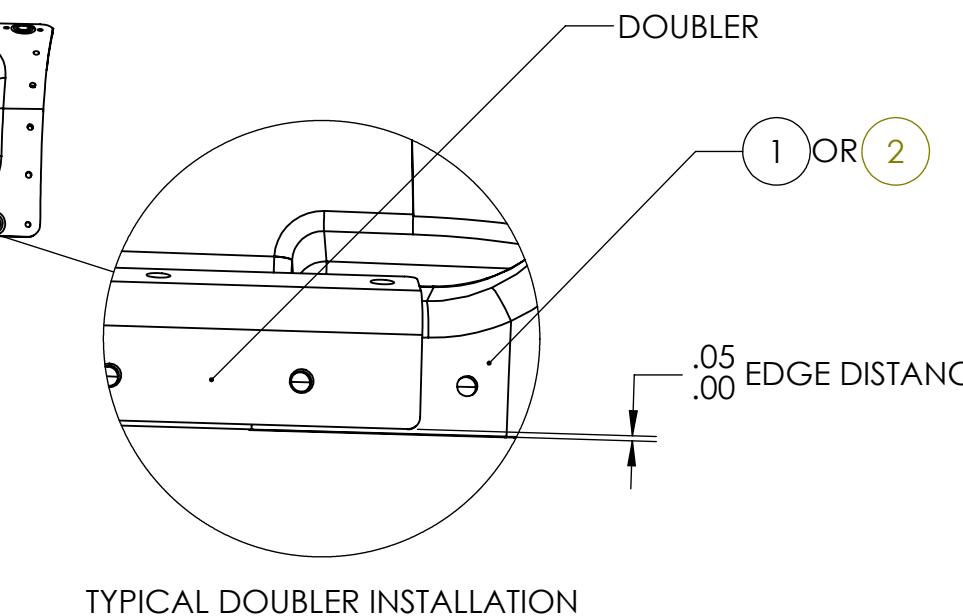
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652.2601



652.2602

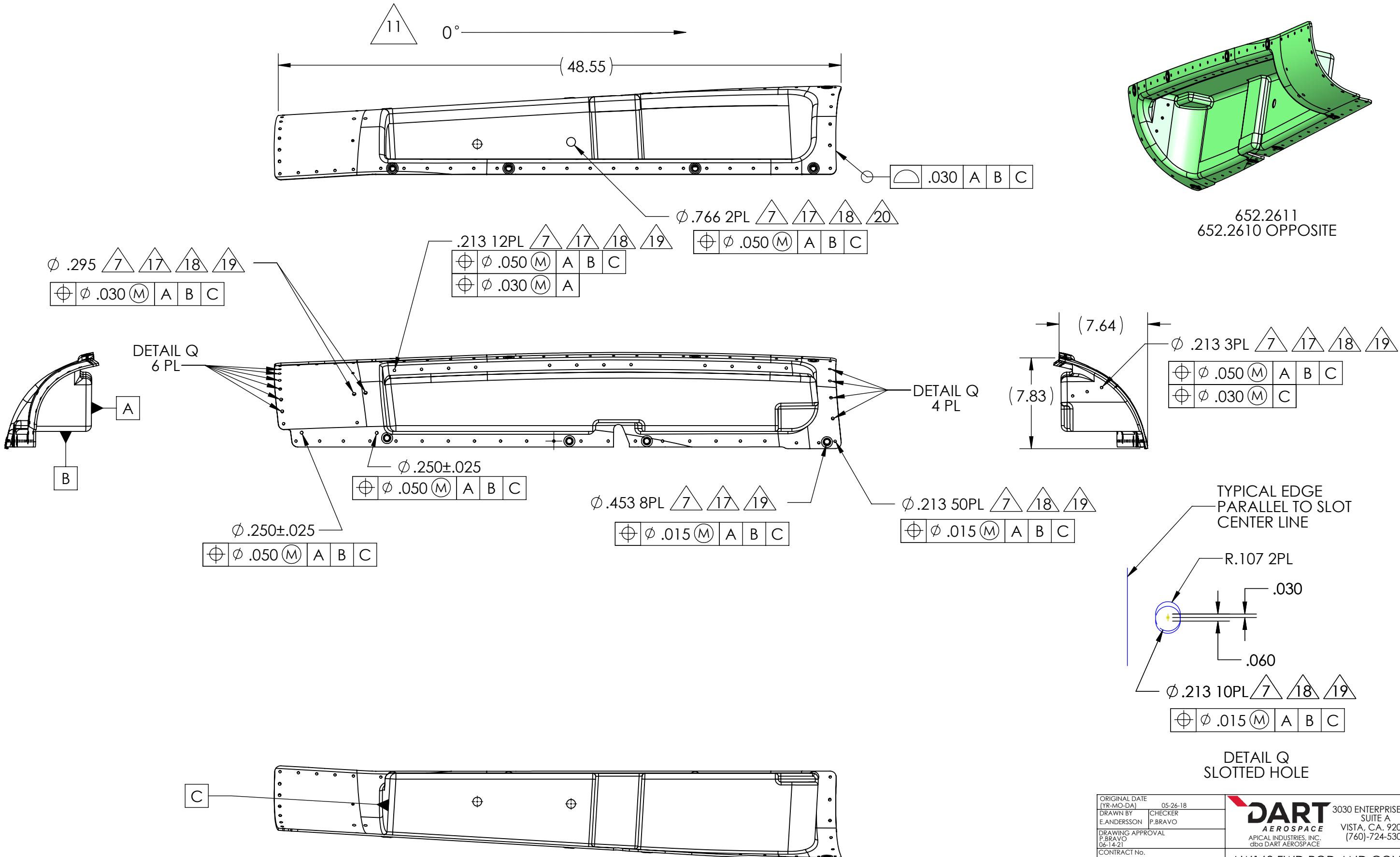
652.2601 SHOWN
652.2602 OPPOSITE

TYPICAL DOUBLER INSTALLATION

ORIGINAL DATE (YR-MO-DA)	05-26-18
DRAWN BY	CHECKER
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DRAWING APPROVAL	
P.BRAVO	06-14-21
CONTRACT No.	

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APICAL INDUSTRIES, INC. dba DART AEROSPACE		
AW169 FWD POD AND COVER		
SIZE	CAGE CODE	DWG. NO.
B	07MZ6	652.2600
REV.		A
SCALE	NONE	SHEET 2 OF 11

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652.2611
652.2610 OPPOSITE

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E.ANDERSSON	P.BRAVO		
DRAWING APPROVAL			
P.BRAVO	06-14-21	CONTRACT No.	
UNLESS OTHERWISE SPECIFIED			
DIMENSIONS ARE IN INCHES			
TOLERANCES ARE:			
2 PLACE DECIMALS $\pm .01$			
3 PLACE DECIMALS $\pm .005$			
ANGLES $\pm .5^\circ$			
SIZE	CAGE CODE	DWG. NO.	REV.
B	07MZ6	652.2600	A
SCALE	NONE	SHEET	3 OF 11

DART
AEROSPACE

3030 ENTERPRISE CT.,
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(760)-724-5300
APICAL INDUSTRIES, INC.
dba DART AEROSPACE

AW169 FWD POD AND COVER

2

3

4

5

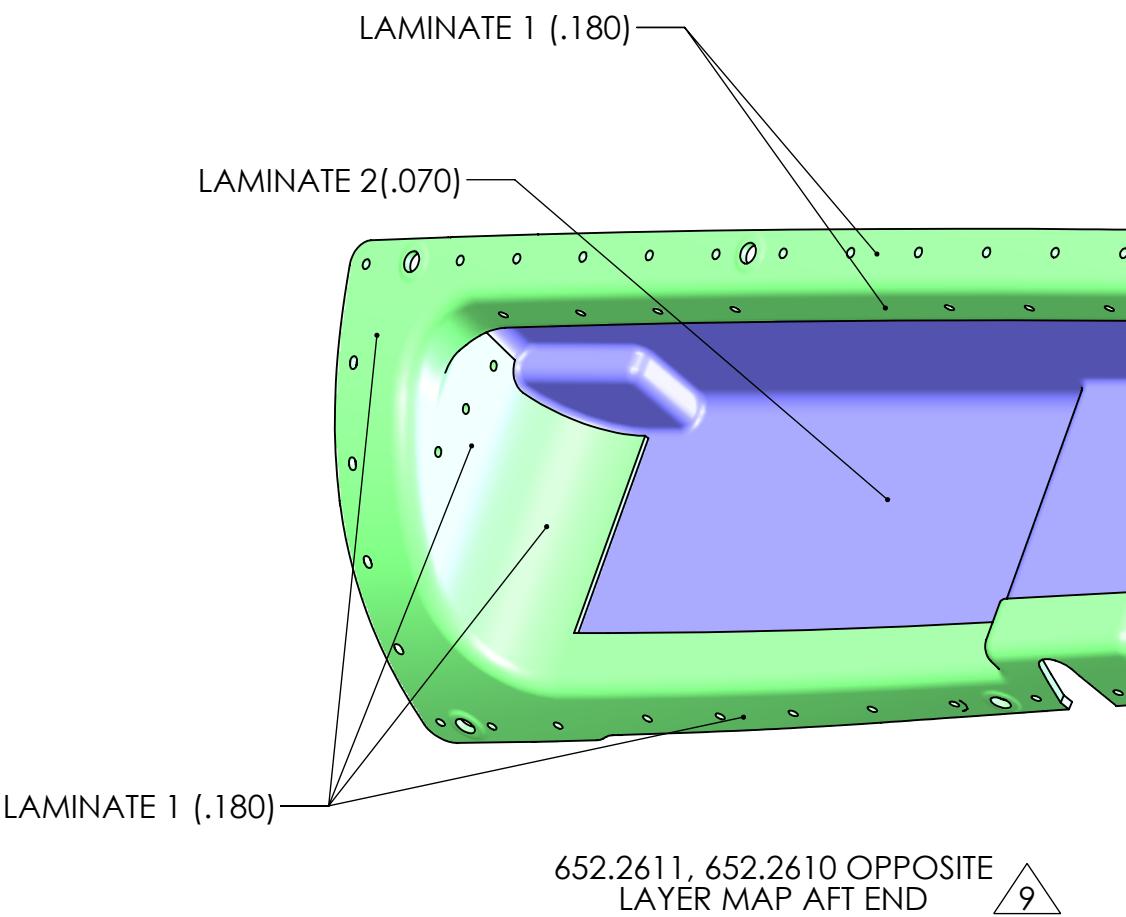
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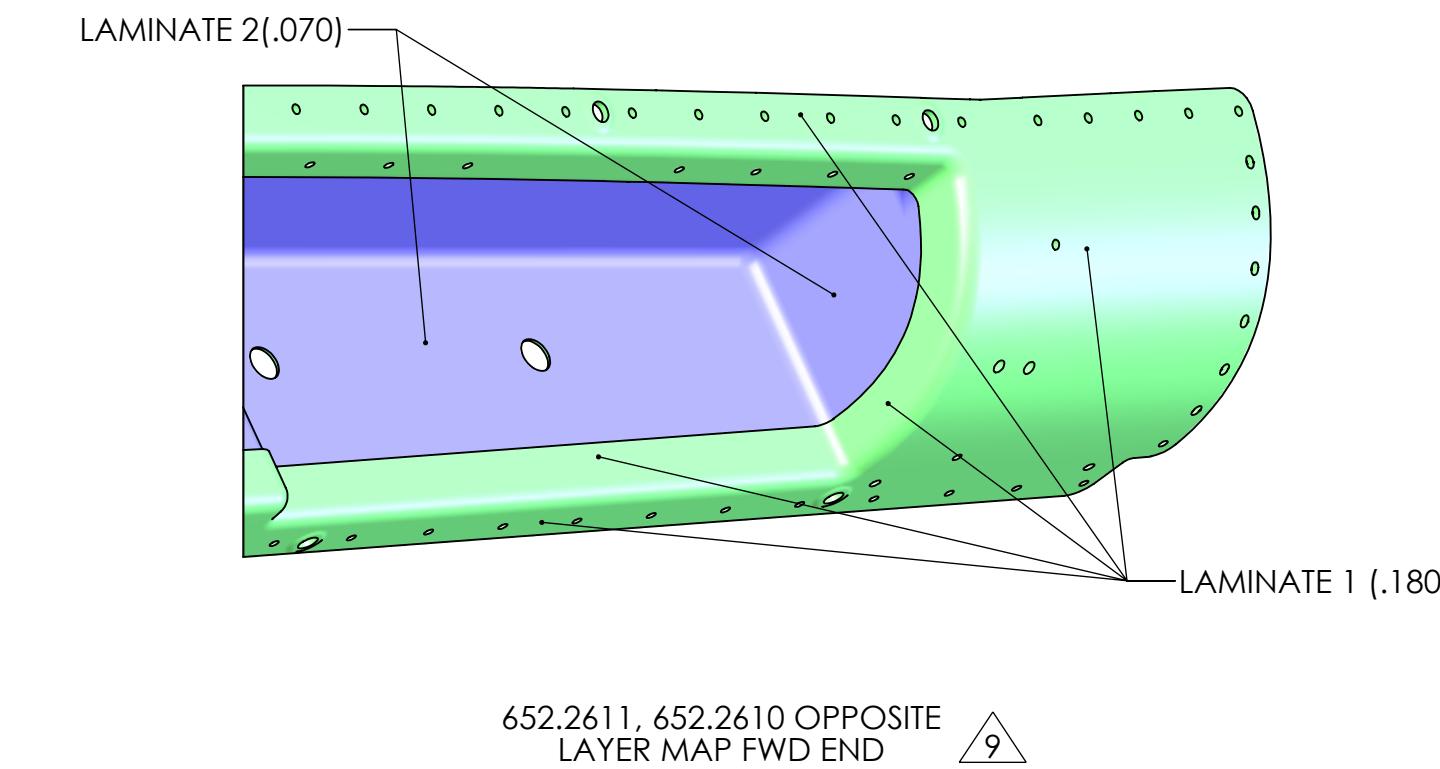
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A



B



C

D

ORIGINAL DATE (YR-MO-DA)	05-26-18	DART AEROSPACE	3030 ENTERPRISE CT., SUITE A, VISTA, CA. 92081 (760)-724-5300
DRAWN BY	CHECKER		APICAL INDUSTRIES, INC. dba DART AEROSPACE
E.ANDERSSON	P.BRAVO		
DRAWING APPROVAL	P.BRAVO 06-14-21		
CONTRACT No.	AW169 FWD POD AND COVER		
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ARE: 2 PLACE DECIMALS $\pm .01$ 3 PLACE DECIMALS $\pm .005$ ANGLES $\pm .5^\circ$	SIZE	CAGE CODE	DWG. NO.
	B	07MZ6	652.2600
			REV. A
		SCALE NONE	SHEET 4 OF 11

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A

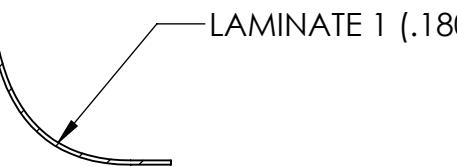
LAMINATE 2(.070)

LAMINATE 1 TRUE LENGTH
FROM EDGE MIN 2.6, MAX 3.3

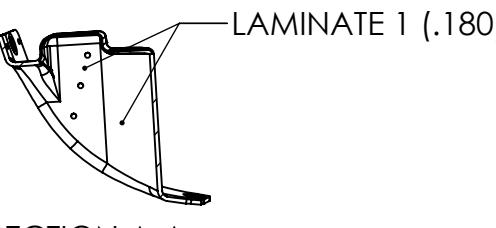
LAMINATE 1 (.180)

1.3 MIN
2.0 MAX

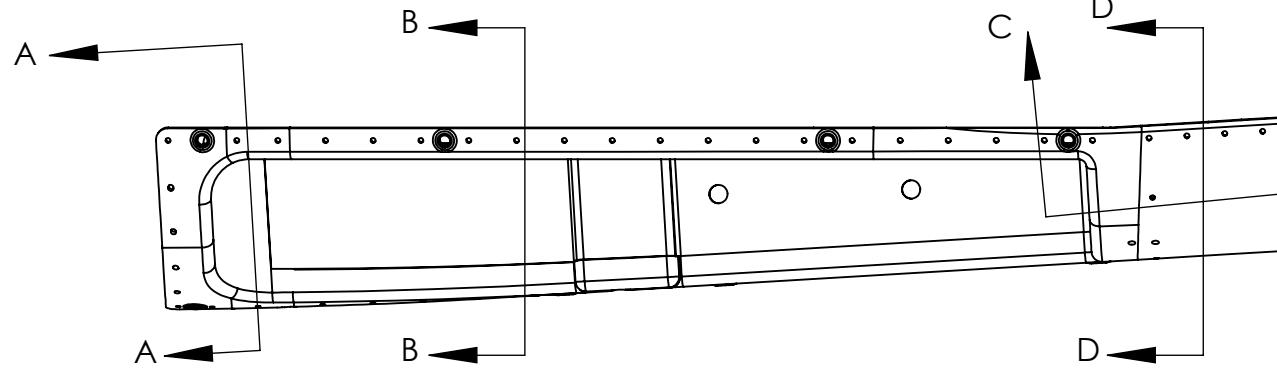
SECTION B-B



SECTION D-D



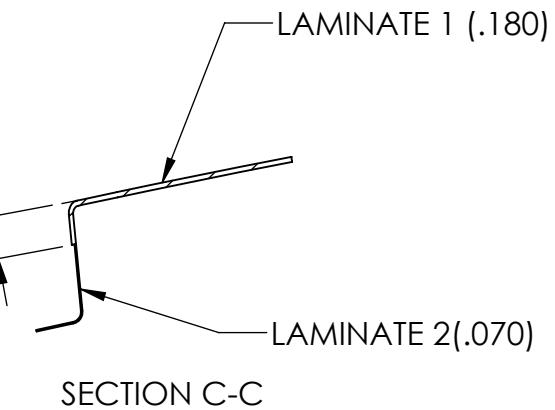
SECTION A-A

652.2611, 652.2610 OPPOSITE
LAYER CROSS SECTIONS

B

C

D

1.8 MIN
2.5 MAX

SECTION C-C

ORIGINAL DATE (YR-MO-DA)	05-26-18
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P.BRAVO	06-14-21
CONTRACT No.	
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ARE: 2 PLACE DECIMALS $\pm .01$ 3 PLACE DECIMALS $\pm .005$ ANGLES $\pm .5^\circ$	

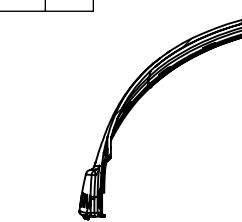
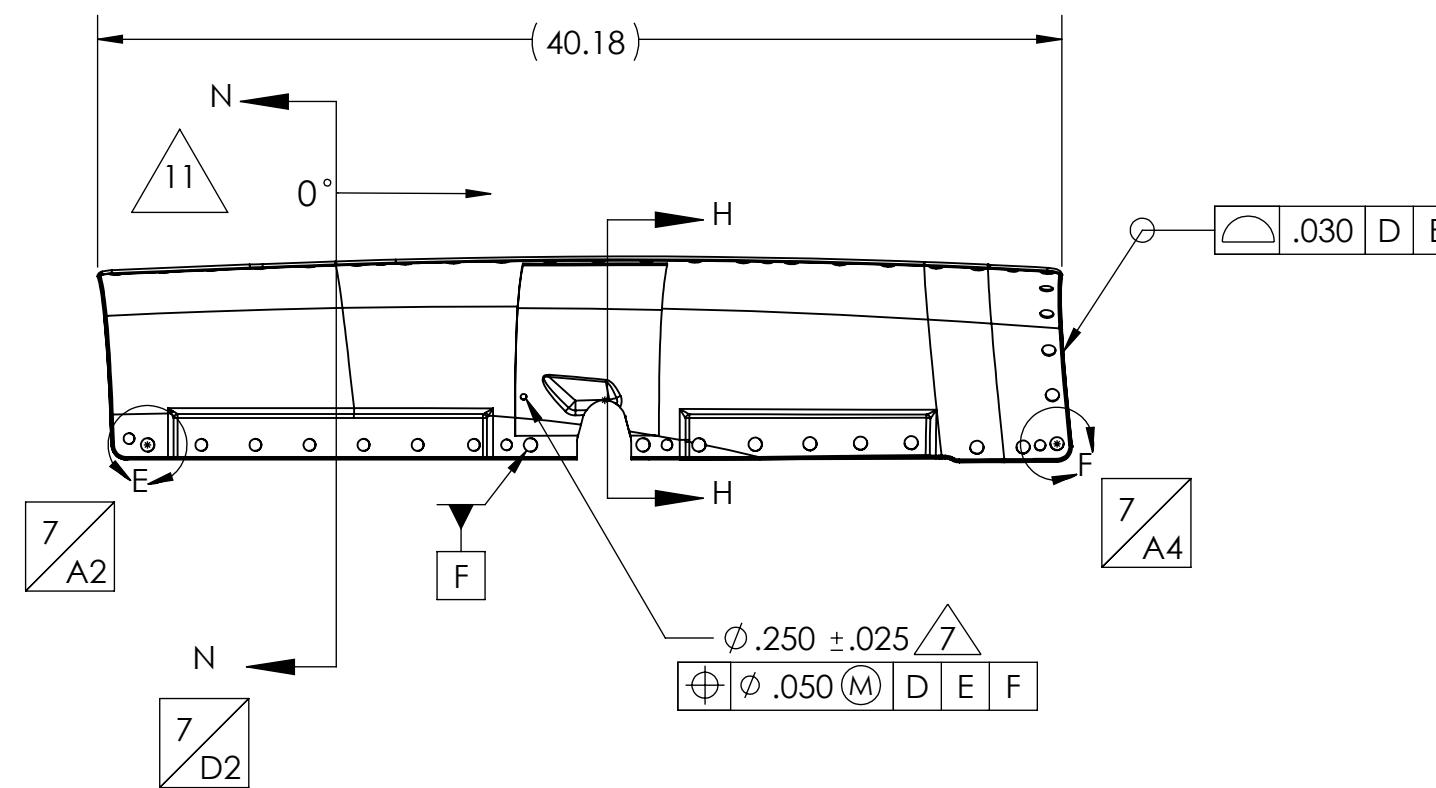
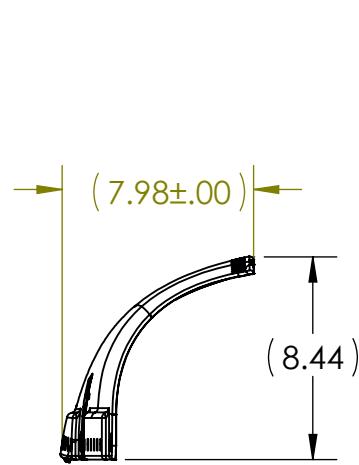
DART AEROSPACE	3030 ENTERPRISE CT., SUITE A, VISTA, CA. 92081 (760)-724-5300 APICAL INDUSTRIES, INC. dba DART AEROSPACE		
AW169 FWD POD AND COVER			
SIZE	CAGE CODE	DWG. NO.	REV.
B	07MZ6	652.2600	A

SCALE NONE

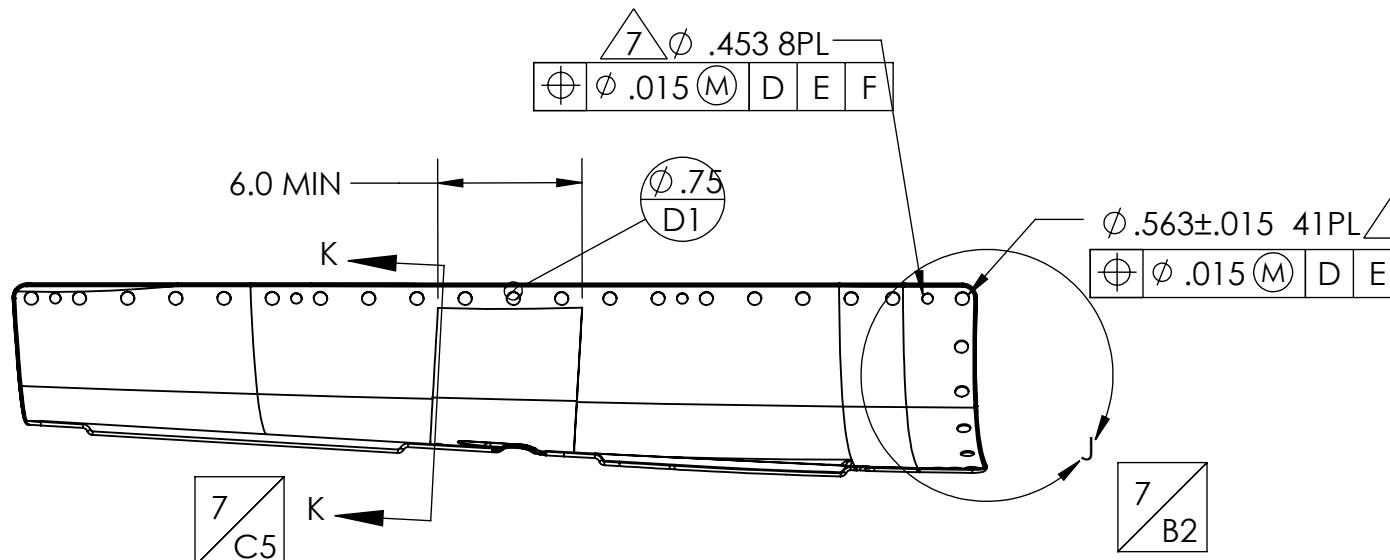
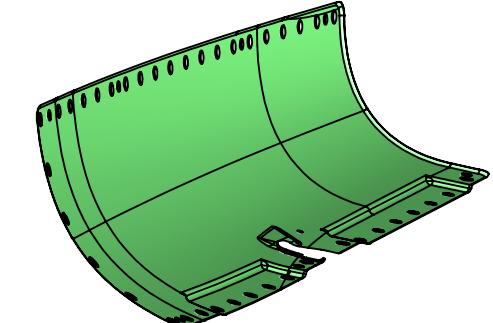
SHEET 5 OF 11

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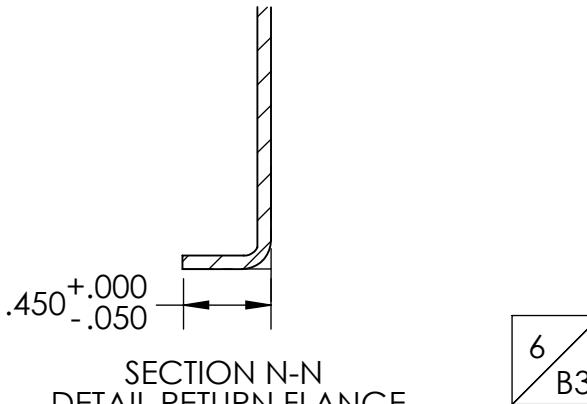
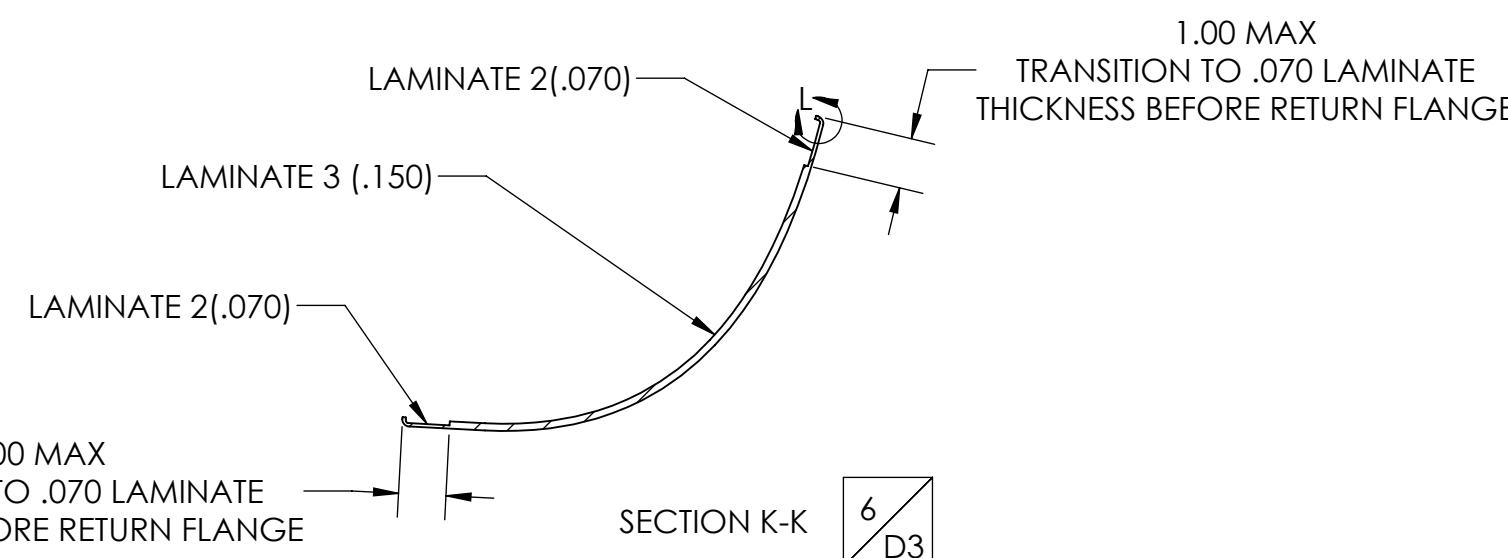
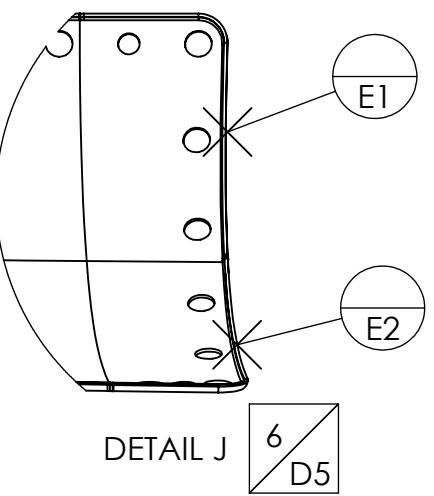
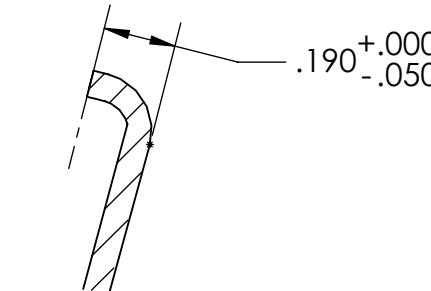
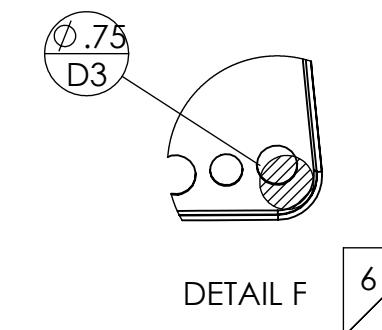
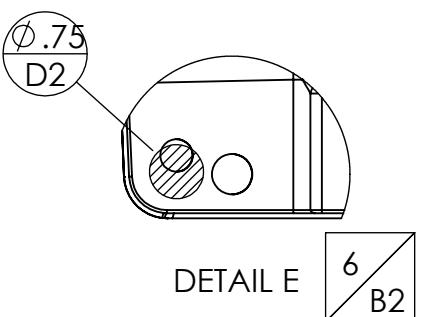


SECTION H-H

652.2613
652.2612 OPPOSITE652.2613
652.2612 OPPOSITE

ORIGINAL DATE (YR-MO-DA)	05-26-18	DART AEROSPACE	3030 ENTERPRISE CT., SUITE A, VISTA, CA. 92081 (760)-724-5300
DRAWN BY	CHECKER		E.ANDERSSON P.BRAVO
DRAWING APPROVAL			P.BRAVO 06-14-21
CONTRACT No.			
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ARE: 2 PLACE DECIMALS ±.01 3 PLACE DECIMALS ±.005 ANGLES ± .5°		AW169 FWD POD AND COVER	
SIZE	CAGE CODE	DWG. NO.	REV.
B	07MZ6	652.2600	A
SCALE	NONE	SHEET	6 OF 11

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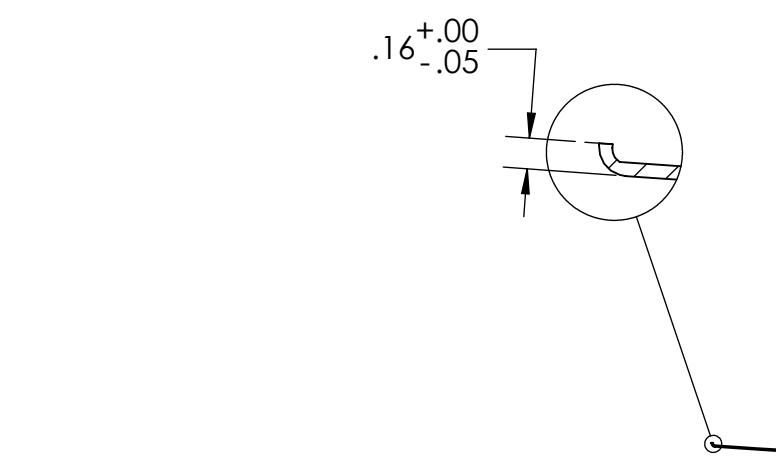
ORIGINAL DATE (YR-MO-DA)	05-26-18
DRAWN BY	CHECKER
E.ANDERSSON	P.BRAVO
DRAWING APPROVAL	
P.BRAVO	06-14-21
CONTRACT No.	

DART
AEROSPACE 3030 ENTERPRISE CT.,
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VISTA, CA. 92081
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dba DART AEROSPACE

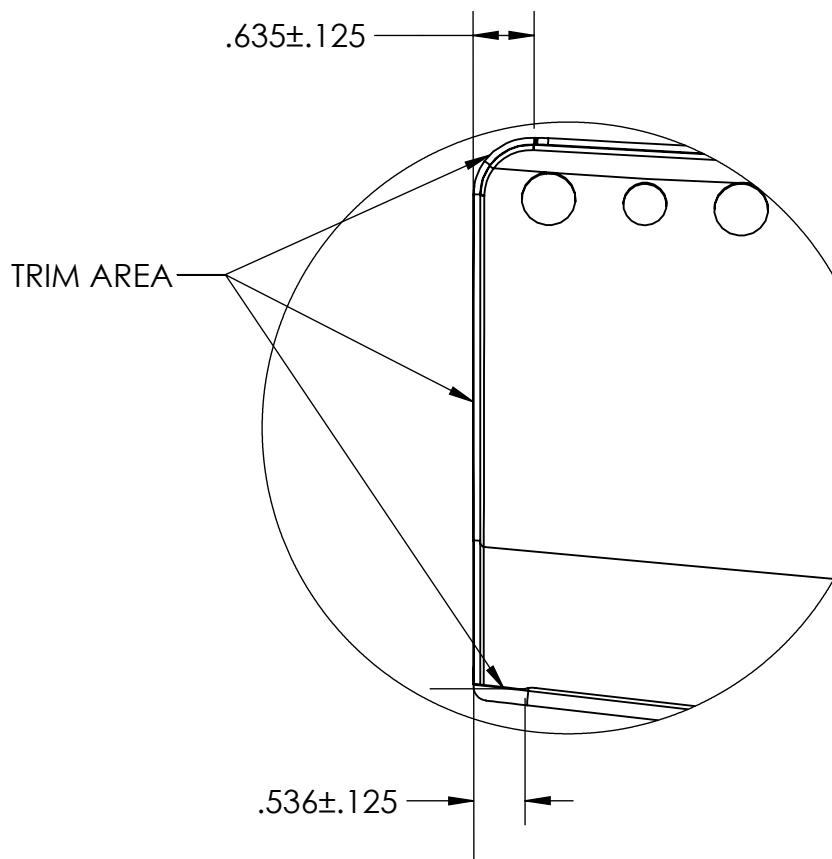
AW169 FWD POD AND COVER
SIZE CAGE CODE DWG. NO. REV.
B 07MZ6 652.2600 A
SCALE NONE SHEET 7 OF 11

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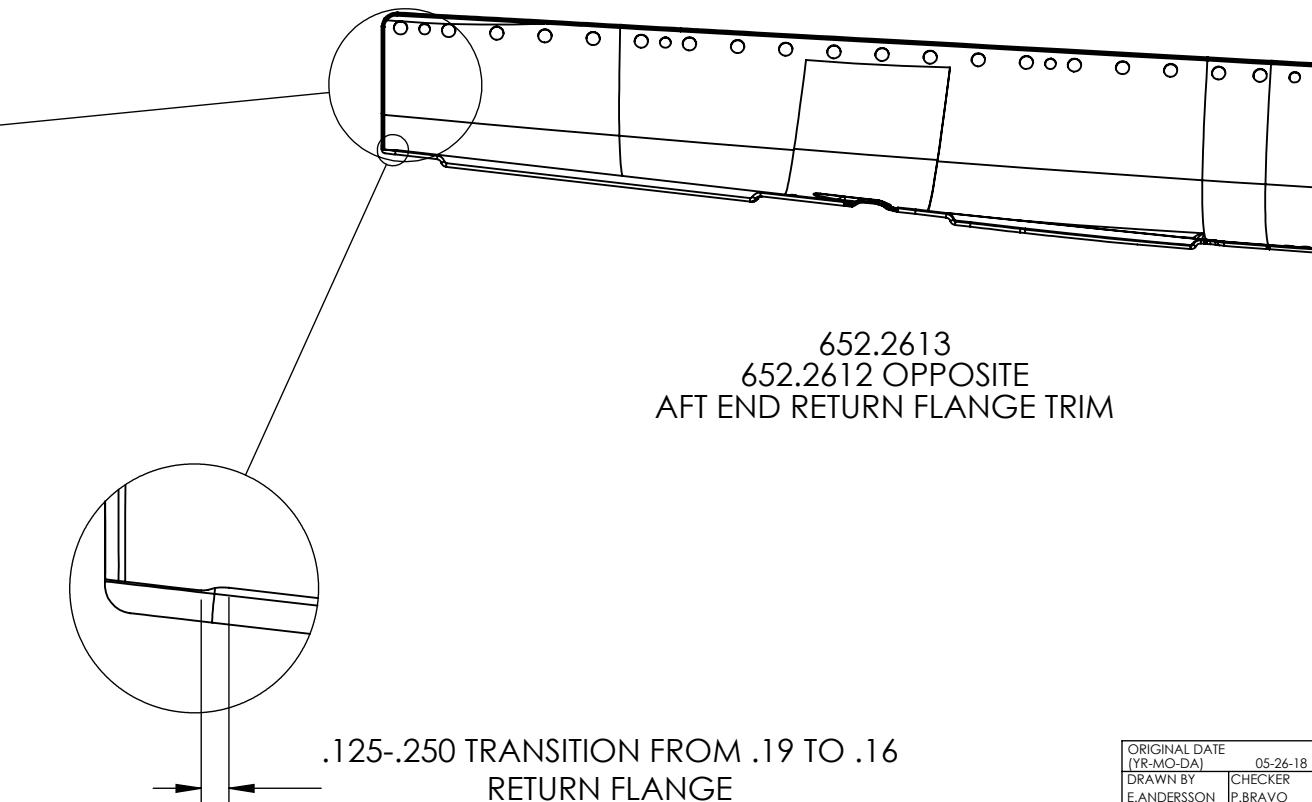
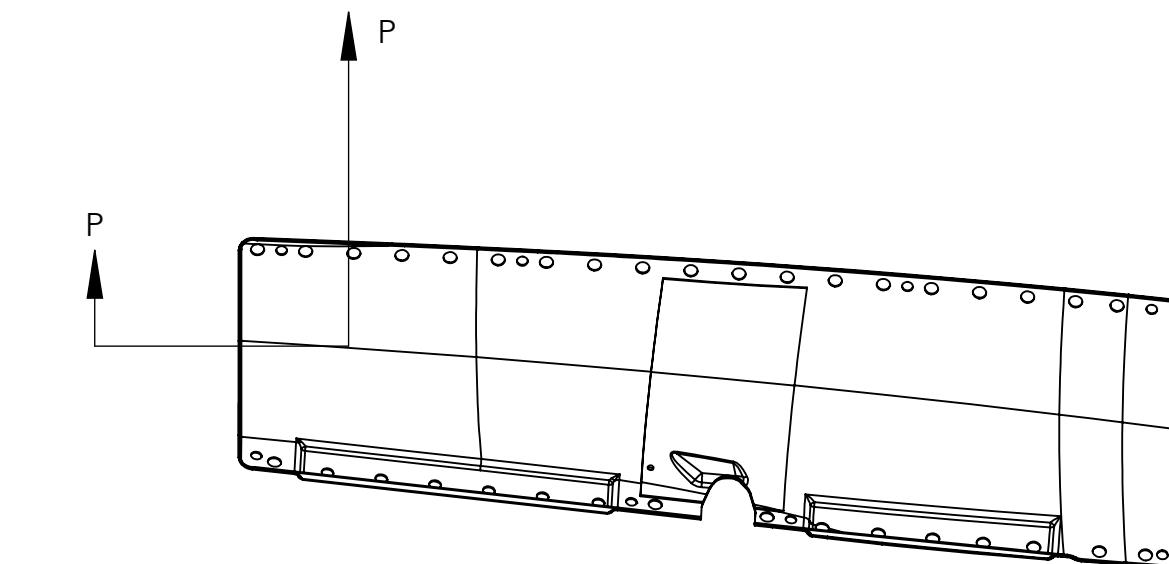
A



B



SECTION P-P



ORIGINAL DATE (YR-MO-DA)	05-26-18
DRAWN BY	CHECKER
E.ANDERSSON	P.BRAVO
DRAWING APPROVAL	
P.BRAVO	06-14-21
CONTRACT No.	
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DART AEROSPACE	3030 ENTERPRISE CT., SUITE A, VISTA, CA. 92081 (760)-724-5300
AW169 FWD POD AND COVER	
SIZE	CAGE CODE
B	07MZ6

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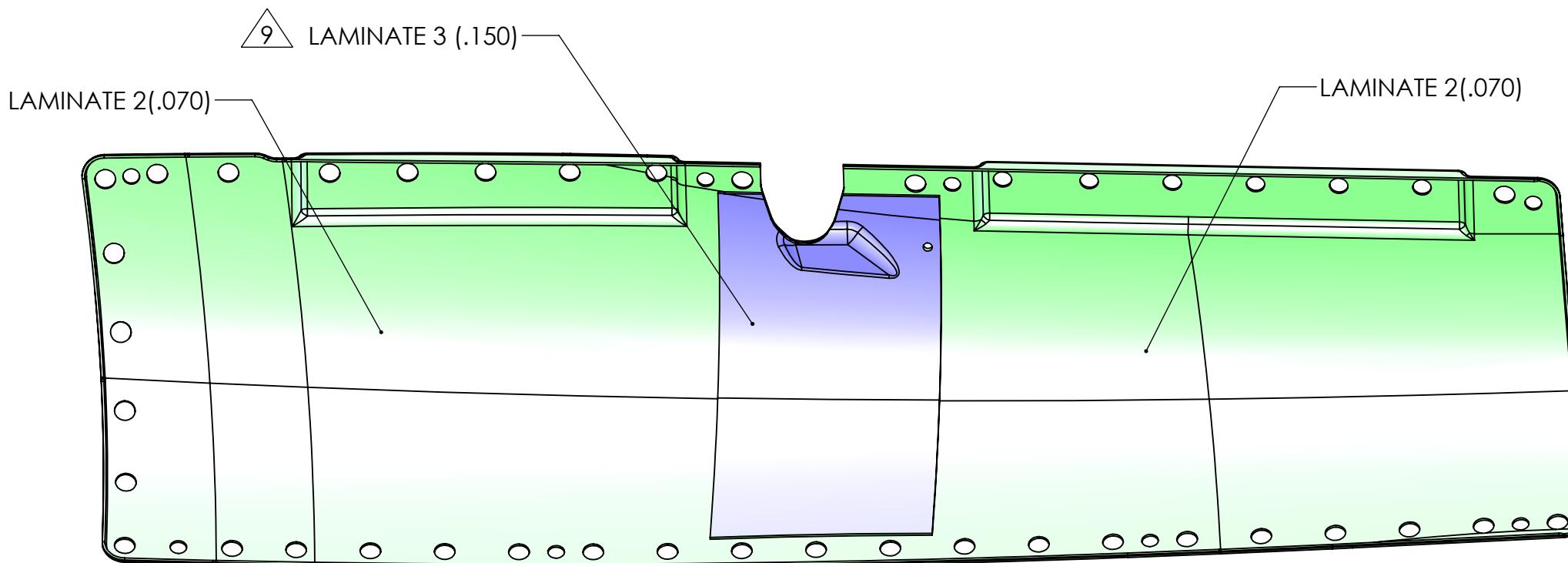
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A

B

C

D

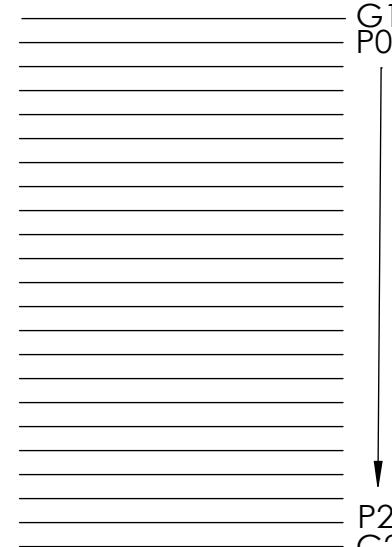


ORIGINAL DATE (YR-MO-DA)	05-26-18	DART AEROSPACE	3030 ENTERPRISE CT., SUITE A, VISTA, CA. 92081 (760)-724-5300
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E.ANDERSSON	P.BRAVO		
DRAWING APPROVAL	P.BRAVO 06-14-21		
CONTRACT No.	AW169 FWD POD AND COVER		
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ARE: 2 PLACE DECIMALS $\pm .01$ 3 PLACE DECIMALS $\pm .005$ ANGLES $\pm .5^\circ$	SIZE	CAGE CODE	DWG. NO.
	B	07MZ6	652.2600
			REV. A
		SCALE NONE	SHEET 9 OF 11

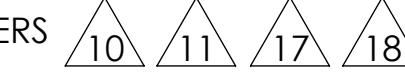
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TOOLING SIDE



LAYUP OF PREPREG LAYERS
.180^{+.050}_{-.010} THICKNESS

LAMINATE 1 - .180in^{+.050}_{-.010} OVERALL THICKNESS

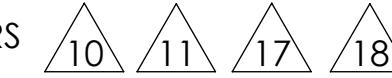
PLY	WARP ANGLE	MATERIAL	THICKNESS
G1	N/A	3	.008-.010
P01	0	2	.008-.010
P02	+45	2	.008-.010
P03	-45	2	.008-.010
P04	90	2	.008-.010
P05	+45	2	.008-.010
P06	-45	2	.008-.010
P07	0	2	.008-.010
P08	+45	2	.008-.010
P09	-45	2	.008-.010
P10	90	2	.008-.010
P11	0	2	.008-.010
P12	90	2	.008-.010
P13	-45	2	.008-.010
P14	+45	2	.008-.010
P15	0	2	.008-.010
P16	-45	2	.008-.010
P17	+45	2	.008-.010
P18	90	2	.008-.010
P19	-45	2	.008-.010
P20	+45	2	.008-.010
P21	0	2	.008-.010
G2	N/A	3	.008-.010



TOOLING SIDE



LAYUP OF PREPREG LAYERS
0.070^{+.030}_{-.015} THICKNESS

LAMINATE 2 - .07in^{+.030}_{-.015} OVERALL THICKNESS

MATERIAL	PLY	WARP ANGLE	THICKNESS
3	G1	N/A	.008-.010
2	P01	0	.008-.010
2	P02	+45	.008-.010
2	P03	-45	.008-.010
2	P04	90	.008-.010
2	P05	-45	.008-.010
2	P06	+45	.008-.010
2	P07	0	.008-.010
3	G2	N/A	.008-.010



ORIGINAL DATE
(YR-MO-DA) 05-26-18
DRAWN BY CHECKER
E.ANDERSSON P.BRAVO
DRAWING APPROVAL
P.BRAVO
06-14-21
CONTRACT No.

DART
AEROSPACE 3030 ENTERPRISE CT.,
SUITE A,
VISTA, CA. 92081
(760)-724-5300
APICAL INDUSTRIES, INC.
dba DART AEROSPACE

AW169 FWD POD AND COVER

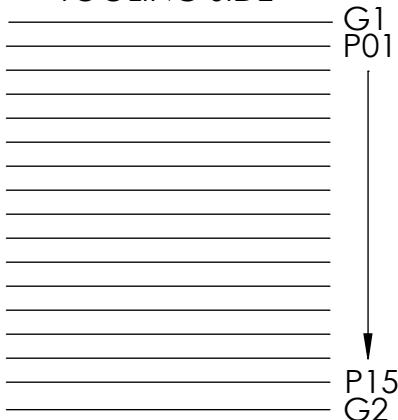
SIZE	CAGE CODE	DWG. NO.	REV.
B	07MZ6	652.2600	A

SCALE NONE SHEET 10 OF 11

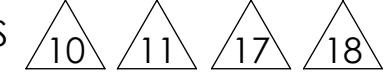
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TOOLING SIDE



LAYUP OF PREPREG LAYERS
.150^{+.030}_{-.030} THICKNESS



LAMINATE 3 - .150in ^{+.030} _{-.030} OVERALL THICKNESS			
PLY	WARP ANGLE	MATERIAL	THICKNESS
G1	N/A	3	.008-.010
P01	0	2	.008-.010
P02	+45	2	.008-.010
P03	-45	2	.008-.010
P04	90	2	.008-.010
P05	+45	2	.008-.010
P06	-45	2	.008-.010
P07	0	2	.008-.010
P08	90	2	.008-.010
P09	0	2	.008-.010
P10	-45	2	.008-.010
P11	+45	2	.008-.010
P12	90	2	.008-.010
P13	-45	2	.008-.010
P14	+45	2	.008-.010
P15	0	2	.008-.010
G2	N/A	3	.008-.010

17

18

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DART AEROSPACE		
3030 ENTERPRISE CT., SUITE A, VISTA, CA. 92081 (760)-724-5300		
APICAL INDUSTRIES, INC. dba DART AEROSPACE		
AW169 FWD POD AND COVER		
SIZE	CAGE CODE	DWG. NO.
B	07MZ6	652.2600
REV.		A
SCALE	NONE	SHEET 11 of 11